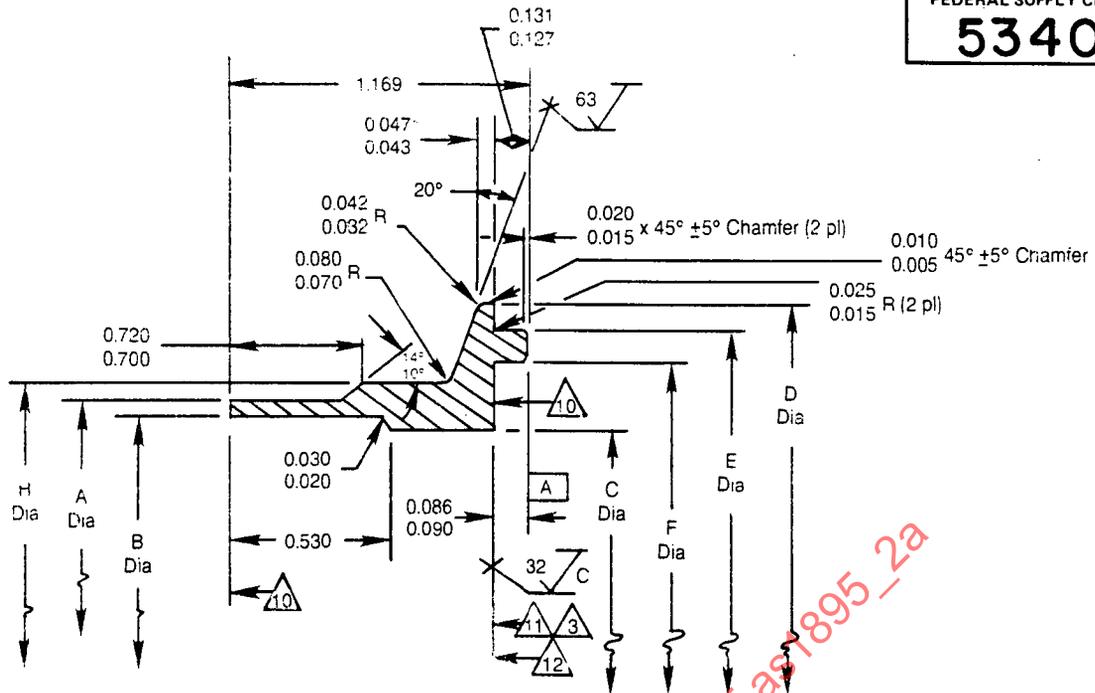


AS1895/2

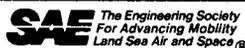
FEDERAL SUPPLY CLASS
5340



PART NUMBER	NOM TUBE SIZE	A DIA +0.000 -0.005	B DIA +0.005 -0.000	C DIA +0.005 -0.000	D DIA +0.005 -0.005	E DIA +0.000 -0.005	F DIA +0.003 -0.000	H DIA +0.000 -0.005	MAX WT IN LBS
AS1895/2-150	1.50	1.600	1.505	1.450	2.250	2.064	1.750	1.687	0.273
AS1895/2-175	1.75	1.850	1.755	1.700	2.500	2.314	2.000	1.937	0.315
AS1895/2-200	2.00	2.100	2.005	1.950	2.750	2.564	2.250	2.187	0.357
AS1895/2-225	2.25	2.350	2.255	2.200	3.000	2.814	2.500	2.437	0.399
AS1895/2-250	2.50	2.600	2.505	2.440	3.250	3.064	2.750	2.687	0.441
AS1895/2-275	2.75	2.850	2.755	2.680	3.500	3.314	3.000	2.937	0.473
AS1895/2-300	3.00	3.100	3.005	2.920	3.750	3.564	3.250	3.187	0.515
AS1895/2-325	3.25	3.350	3.255	3.170	4.000	3.814	3.500	3.437	0.567
AS1895/2-350	3.50	3.687	3.505	3.410	4.250	4.064	3.750	3.687	0.714
AS1895/2-400	4.00	4.187	4.005	3.900	4.750	4.564	4.250	4.187	0.798
AS1895/2-450	4.50	4.687	4.505	4.380	5.250	5.064	4.750	4.687	0.914
AS1895/2-500	5.00	5.187	5.005	4.870	5.750	5.564	5.250	5.187	1.019
AS1895/2-550	5.50	5.687	5.505	5.360	6.250	6.064	5.750	5.687	1.134
AS1895/2-600	6.00	6.187	6.005	5.850	6.750	6.564	6.250	6.187	1.250

SHEET	1	2	3
REV.	A	A	A

CUSTODIAN: G-3/G-3A PROCUREMENT SPECIFICATION: AS1895



400 Commonwealth Drive
Warrendale, PA 15096

AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD TYPE 1
(STANDARD PROFILE)

AS 1895/2

SHEET 1 OF 3

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ISSUED 12-85 REVISED (A) 2-88

NOTES:

1. Construction and Performance:

This flange, when mated with flange end per AS1895/13-XXX, flange P/N AS1895/3-XXX, Flange P/N AS1895/11-XXX, seal P/N AS1895/7-XXX, and coupling P/N AS1895/1-XXX, shall meet all the requirements of specification AS1895.

2. Material:

Dash Numbers 150 through 350 - Nickel Alloy 625 in accordance with AMS 5666 or AMS 5599.
Dash Numbers 400 to 600 - Nickel Alloy 718 in accordance with AMS 5596 or AMS 5662 in the precipitate hardened condition.

3

Sealing surface shall be free of scratches and surface finish shall be circular and concentric to bore diameter.

4. Do not use unassigned part codes.

5. Finish:

Descaled. Free of surface contamination.

6. Inspection Requirement - Manufacturer:

Penetrant inspect all flanges in accordance with MIL-I-6866.

7. Workmanship:

The flanges shall be free of sharp edges and burrs and shall be capable of mating under all tolerance conditions of the component parts.

8. Tolerances:

.XXX = ± 0.10 , .XX = ± 0.03 , angles = $\pm 1/2^\circ$.

9. Concentricity:

All diameters shall be concentric to bore diameter within .004 TIR.

10

Perpendicularity:

Noted surface to be perpendicular to \underline{G} within .004 TIR.

11

Flatness:

Noted surface to be flat within .003 TIR.

12

Parallelism:

Noted surfaces to be parallel with surface marked \boxed{A} within .003 TIR.

13. All surfaces to be $\sqrt{125}$ except as noted.

14. Marking:

Mark packaging with supplier identification and AS1895/2-XXX part number.

15. Flatness Limit After Welding is .005 TIR. Exception:

For sizes 500 thru 600 (5.00-6.00 inch) .007 TIR is acceptable.

CUSTODIAN: SAE G-3/G-3A

PROCUREMENT SPECIFICATION: AS1895

AEROSPACE STANDARD

FLANGE, MALE, SEAM WELD, TYPE 1
(STANDARD PROFILE)

AS 1895/2

SHEET 2 OF 3